Date: Thursday, [illegible]/2007 12:07:45 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT TUBE ASSEMBLY
Job Number	: 30697		
Estimate Number	: 10699		
P.O. Number	: N/A	Part Number	: D3391025
This Issue	: 2/8/2007 S.O. No. : N/A	Drawing Number	: D3391 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: E
Previous Run	: 30696	Material	: N/A
Written By	:	Due Date	: 3/2/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.02.08		
Comment	: Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev:C 06-03-28 Update Manufacturing Instructions JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6014090	ALUMINUM EXTRUSION

Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)
ALUMINUM EXTRUSION
Pick:
Qty Part Number Description Batch B26546
1 D6014-090 Extrusion _____
Identify as D3391-3
JB 07/02/13

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE

Comment: MORI SEIKI CNC LATHE LARGE
Turn as per Folio FA599 Rev: ___ & Dwg D3391 Rev: E
JB 07/02/13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE
JB 07/02/14

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS
1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: E
2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803
3-Deburr
JB 07/02/15

Part A

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** _____ **Date:** 07/02/27

QA: N/C Closed: _____ **Date:** _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:

DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
6/26/15	# 4.2	Drill Jig moved when Drill in Pilot hole on apt of take Chuck A Double hole.	~~DT~~ 07.02.21 RPI QSI 042	OPEN HOLE TO FINISHED SIZE OF Ø0.209 VERIFY IF ANY HOLE ELONGATION IS PRESENT	07/02/15	07.02.21	QSI 042	07.02.21

NOTE: Date & initial all entries

ate: Thursday, 2/8/2007 12:07:45 PM
er: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT TUBE ASSEMBLY

Job Number: 30697 **Part Number:** D3391025

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE SN 07/02/15 x (

6.0	QC8	SECOND CHECK

Comment: SECOND CHECK SA 07.02.21

7.0	BENDING	BENDING MACHINE

Comment: NC Bender
Form as per Dwg D3391 Using Bend Prog 3391025 DP 7-2-21

8.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP BE 07-02-21

9.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1
1-Open Aft cap pilot hole to .208" as per Dwg D3391 ← VERIFY IF ANY HOLE ELONGATION EXISTS

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig } BE 07-02-22

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

5-Deburr JD 7-1-21

(10)

Tools: rill

10.0	QC5	INSPECT WORK TO CURRENT STEP

PH 07.02.23

Comment: INSPECT WORK TO CURRENT STEP ~~Refer to let us know - DNT continue~~ ~~no sssly~~

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1 M.M 01/02/24 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** [illegible] **Date:** 07/02/27

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B **Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
07-02-23	Q-0	During Step 4.2, the AFT gear hole was started enocked. Hole is to be verified when opened @ step 9.0.	QS 10/2	Hole has a little mark on the outside edge. Hole ACCEPTABLE. Minor IN Appearance.	BE 07-02-23	07-02-23	QS 10/2	07-02-23.

NOTE: Date & initial all entries

Date: Thursday, 2/8/2007 12:07:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT TUBE ASSEMBLY

Job Number: 30697 **Part Number:** D3391025

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	POWDER COATING	POWDER COATING

M103141 (1)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 m.R/a.m 07/02/24

13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION SAD 07/02/24 (1)

14.0	NAS1330C3KB166	INSERT

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
INSERT
Pick:

Qty	Part Number	Description	Batch
8	NAS1330C3KB166	Insert	B100732

a.m 07/02/24 (1)

15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Install Inserts as per dwg a.m 07/02/24 (1)

16.0	QC5	INSPECT WORK TO CURRENT STEP

07-02-26 (1) ~~a.m 07/02/24~~ (1)

Comment: INSPECT WORK TO CURRENT STEP

17.0	AESS10KB366	INSERT

Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
Insert
Pick:

Qty	Part Number	Description	Batch
14	AESS10KB366	Insert	M102642

a.m 07/02/24 (1)

18.0	AESS10KB266	INSERT

(1)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
INSERT
Pick:

Qty	Part Number	Description	Batch
2	AESS10KB266 or NAS1330C3KB266	Insert	B17905

m.R/a.m 07/02/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng		**Action Description** Chief Eng	**Sign & Date**		

NOTE: Date & initial all entries

Date: Thursday, 2/8/2007 12:07:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT TUBE ASSEMBLY

Job Number: 30697 **Part Number:** D3391025

Job Number:

Seq. #:	Machine Or Operation:	Description :
19.0	AESS10KB316	INSERT

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
INSERT
Pick:

Qty	Part Number	Description	Batch
2	AESS10KB316 or NAS1330C3KB316	Insert	M17905 M.H/am 02/02/24 (1)

20.0	D2646	Aft Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Aft Cap
Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	B30119

21.0	AN3C4A	BOLT

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	m01390

22.0	AN960C10L	washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Inventory
Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	m10334

23.0	NAS1515H3L	WASHER

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	m10348 M.H/am 02/02/24 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B				**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng		**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Thursday, 2/8/2007 12:07:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT TUBE ASSEMBLY

Job Number: 30697 **Part Number:** D3391025

Job Number:

Seq. #:	Machine Or Operation:	Description :
24.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Install inserts as per Dwg D3391

a.m/[illegible] 07/02/24 U

2-Install Aft Cap as per Dwg D3391
A/R Sikaflex-241/-291 M102672
Sikaflex expiry date: 02/07

25.0	QC5	INSPECT WORK TO CURRENT STEP

07-02-26 (U)

Comment: INSPECT WORK TO CURRENT STEP

26.0	PACKAGING 1	PACKAGING RESOURCE #1

POSITIVE RECALL

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____

EFFECTIVE 07.02.23 **AUTH** PH
RELEASED 07-02-23 **DATE** PH

27.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

07/02/27 (1)

Job Completion

U 07.02.26

Form: process

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng		**Action Description** Chief Eng	**Sign & Date**		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30697
Description: Float Skidtube (412)	Part Number:	D3391-3
Inspection Dwg: D3391 **Rev:** E		Page 1 of 1

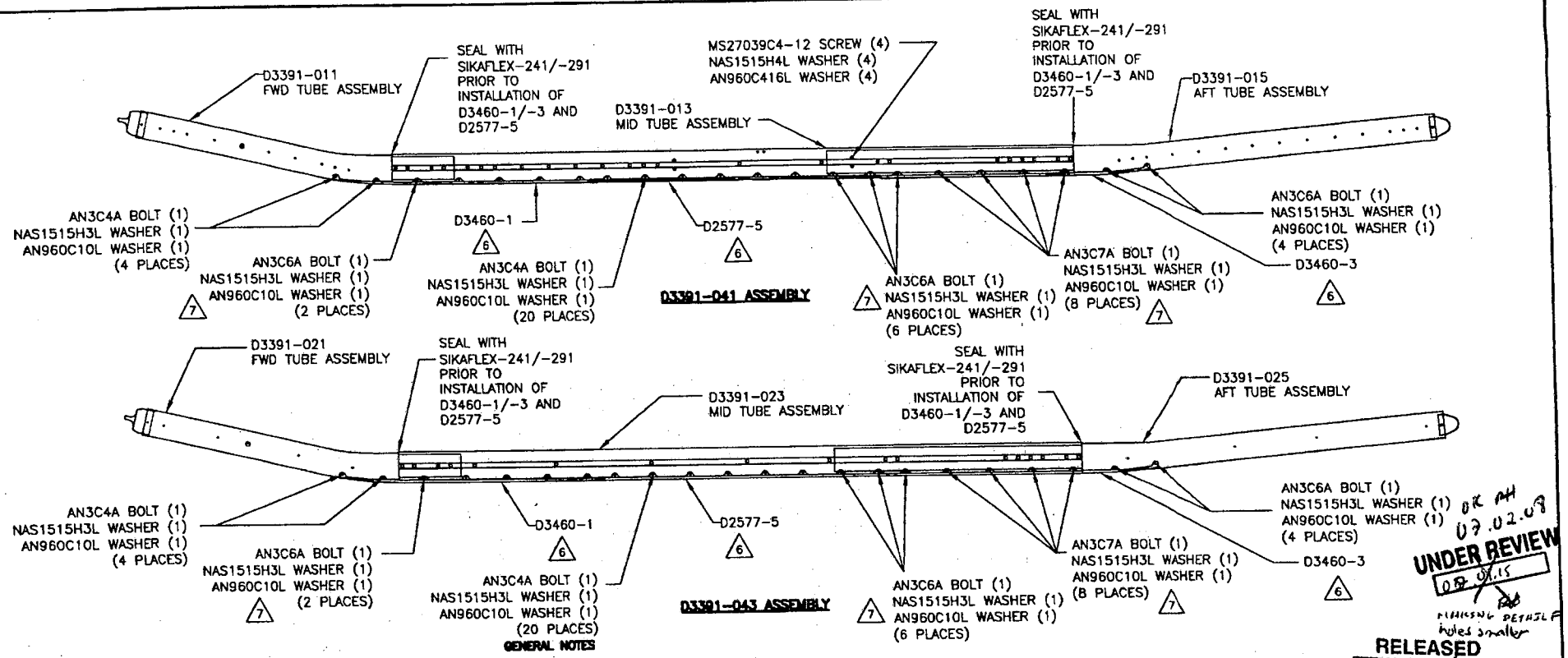
FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.00	✓			
3.500	+/-0.010	3.495	✓			
88.93	+/-0.030	88.93	✓			
2 44.995	+/-0.030	44.98	✓		Tape	
3.200	+/-0.010	3.205	✓			
1.526	+0.000/-0.030	1.526	—			
0.200	+/-0.010	0.202	✓			
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	—		~~Tape~~	
31.750	+/-0.010	31.750	—		~~Tape~~	
35.250	+/-0.010	35.250	—		~~Tape~~	
0.400	+/-0.010	0.400	—			
PA 07.02.21 ? ~~Ø0.208~~	~~+0.005/-0.001~~					
3.300	+/-0.010	3.301 / 3.310	—			
0.200	+/-0.010	0.202	—			
3.520	+/-0.010	3.530	✓			
0.687	+0.010/-0.000	0.687	—			
R0.062	+/-0.010	0.062	—			
Ø0.484	+0.005/-0.001	0.486	—			

Measured by:	S.P	Audited by:	SA	Prototype Approval:	N/A
Date:	07/02/13	Date:	07.02.21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3391-041	FLOAT SKIDTUBE ASSEMBLY
	X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

GENERAL NOTES

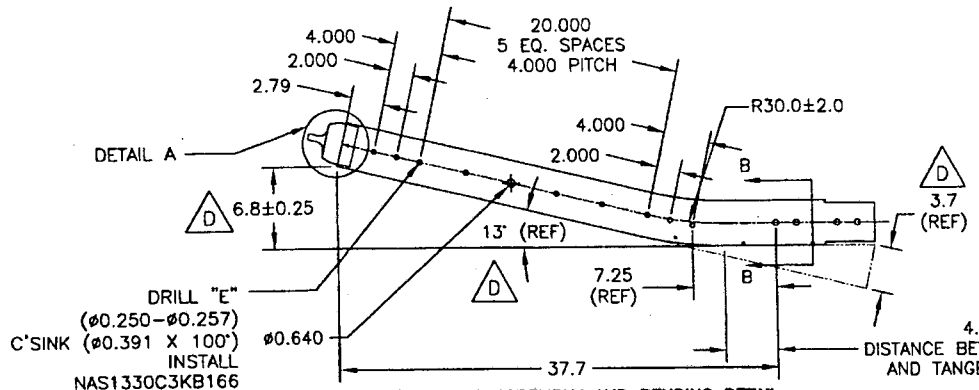
1) ALL DIMENSIONS ARE IN INCHES
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
   POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (ø0.250-ø0.257) FOR WEARSHOE INSERTS. C'SINK ø0.391/ø0.425 x 100° AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
6) APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
7) DO NOT TORQUE, HAND TIGHTEN ONLY

E	06.04.25	CHANGE TOLERANCE,EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE

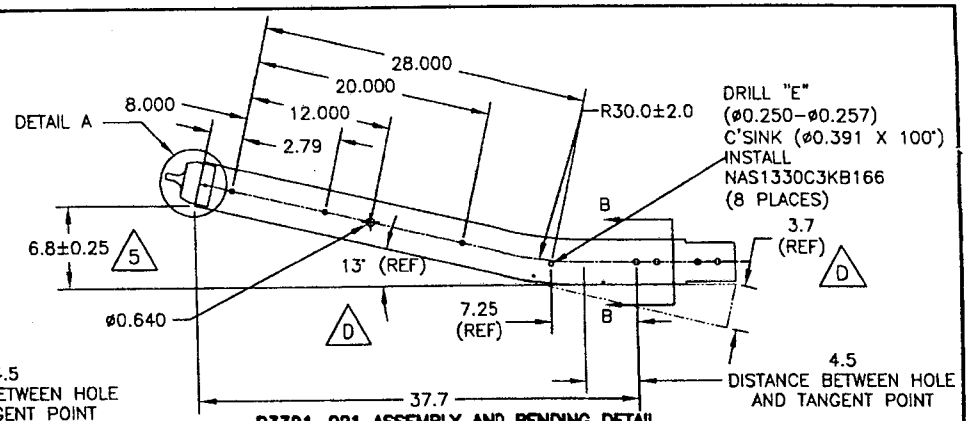
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
PH	PH	
CHECKED	APPROVED	DRAWING NO. D3391 — REV. E
		SHEET 1 OF 5
DATE 06.04.25		TITLE 412 FLOAT SKIDTUBE — SCALE NTS

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO 32627

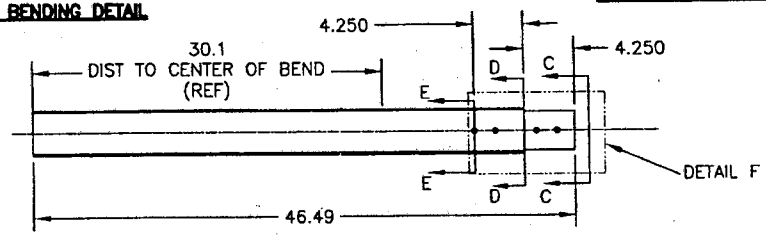
OK PH 07.02.09
UNDER REVIEW
07.04.15
PUNCH DETAIL F holes smaller
RELEASED
06.05.03



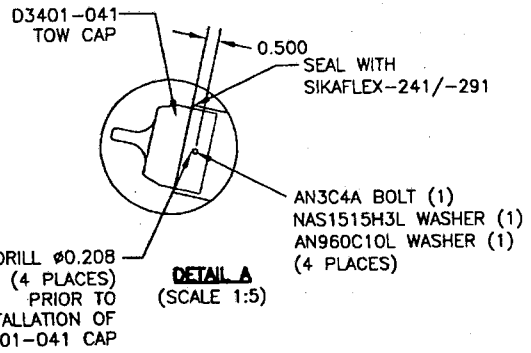
D3391–011 ASSEMBLY AND BENDING DETAIL



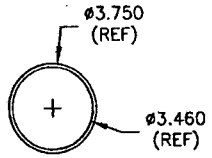
D3391–021 ASSEMBLY AND BENDING DETAIL



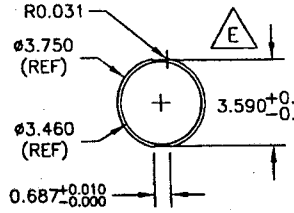
D3391–1 DRILLING AND CUTTING DETAIL
(MAKE FROM D6013–047 SKIDTUBE MATERIAL)



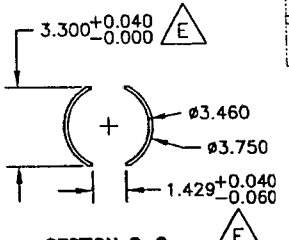
DETAIL A
(SCALE 1:5)



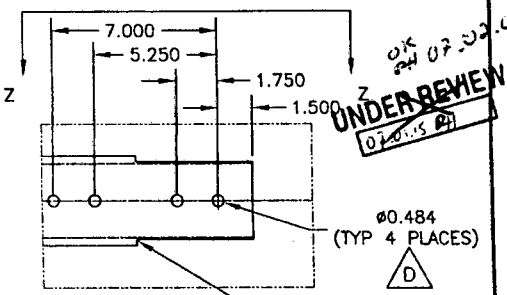
SECTION E–E
(SCALE 1:5)



SECTION D–D
(SCALE 1:5)



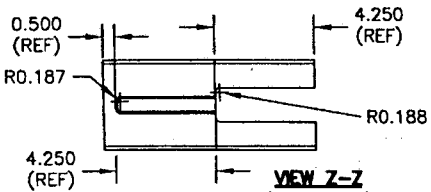
SECTION C–C
(SCALE 1:5)



DETAIL F
(SCALE 1:5)

SECTION B–B
(SCALE 1:5)

5 DRILL "E"
(ø0.250–ø0.257)
C'SINK (ø0.391 X 100°)
INSTALL
NAS1330C3KB166
(6 PLACES)



VIEW Z–Z
(SCALE 1:5)

D3391–011/–021 FWD TUBE ASSEMBLY PARTS LIST

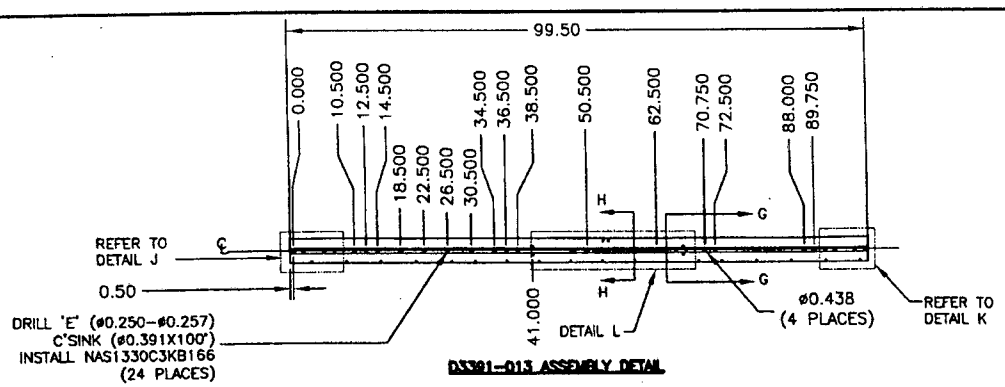
QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
4	4	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER
24	14	NAS1330C3KB166	INSERT

OK PH 07.02.03

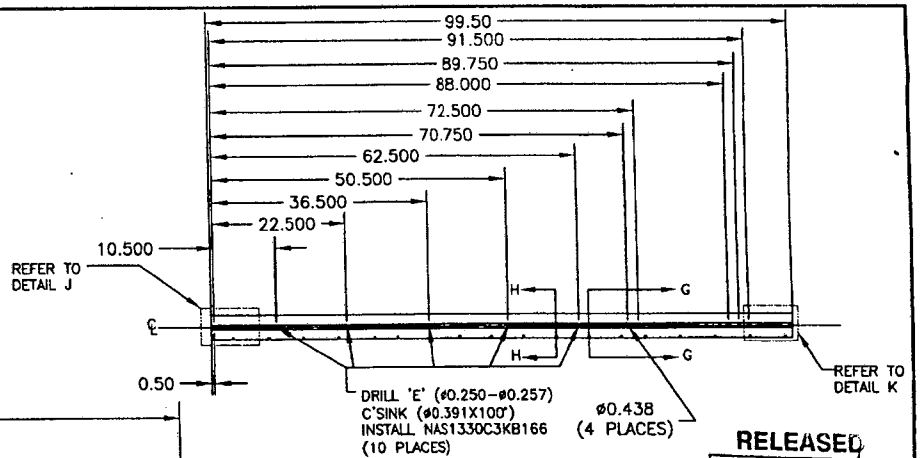
UNDER REVIEW 07.01.15

RELEASED 06.05.03

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
PH	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3391 REV. E
DATE 06.04.25		SHEET 2 OF 5
		TITLE 412 FLOAT SKIDTUBE SCALE 1:10

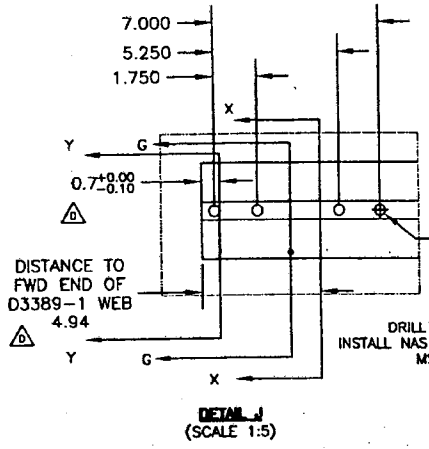


D3391-013 ASSEMBLY DETAIL

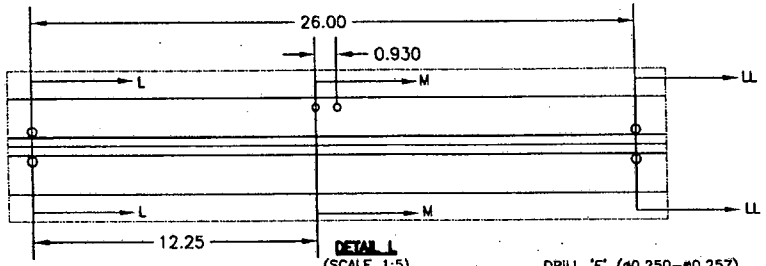


D3391-023 ASSEMBLY DETAIL

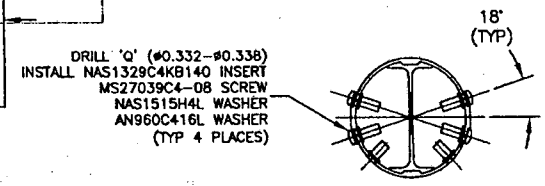
RELEASED
06.05.04



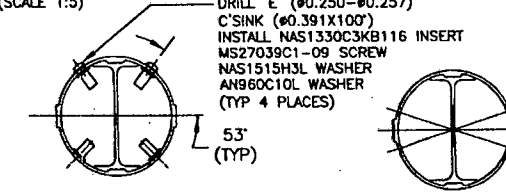
DETAIL J
(SCALE 1:5)



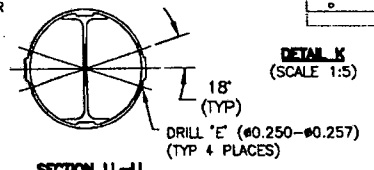
DETAIL L
(SCALE 1:5)



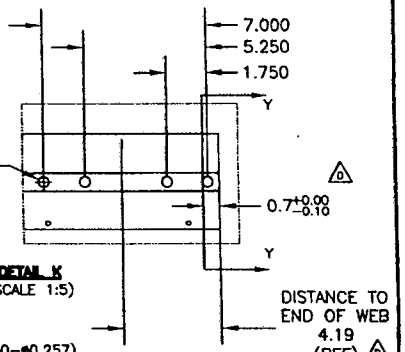
SECTION L–L
(SCALE 1:4)



SECTION M–M
(SCALE 1:4)



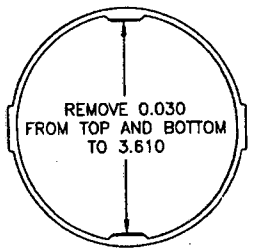
SECTION U–U
(SCALE 1:4)



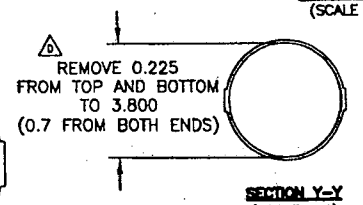
DETAIL K
(SCALE 1:5)

D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

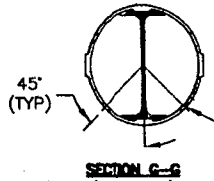
QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW



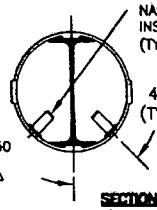
SECTION X–X
(SCALE 1:2)



SECTION Y–Y
(SCALE 1:4)



SECTION G–G
(SCALE 1:4)

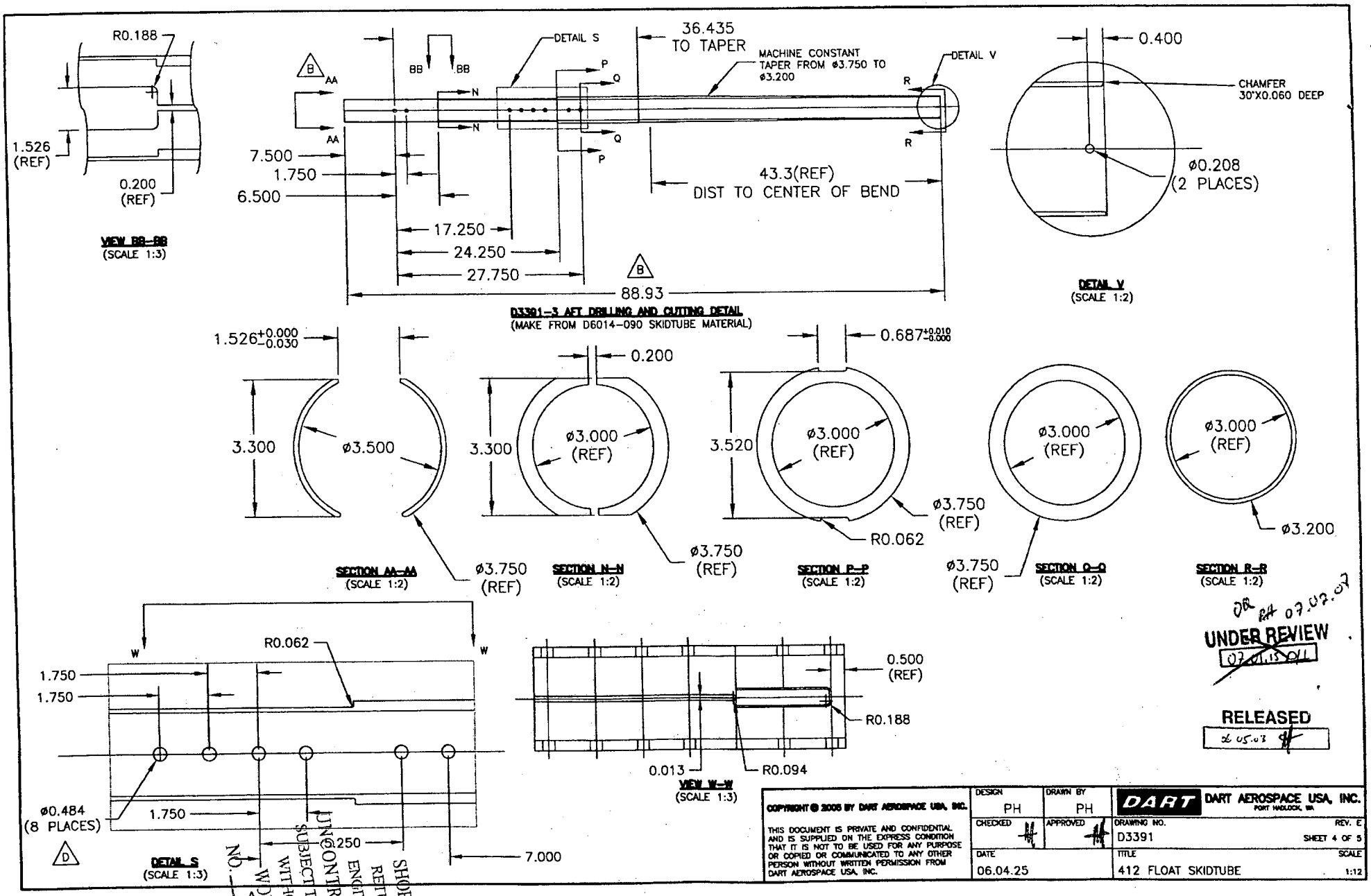


SECTION H–H
(SCALE 1:4)

UNDER REVIEW
07.01.04

D3391-013/-023 MID TUBE ASSEMBLY
1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-29 PER QSI-015

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
PH	PH	
CHECKED	APPROVED	DRAWING NO. D3391 REV. E
		SHEET 3 OF 5
DATE 06.04.25		TITLE 412 FLOAT SKIDTUBE SCALE 1:20



DR RA 07.02.07

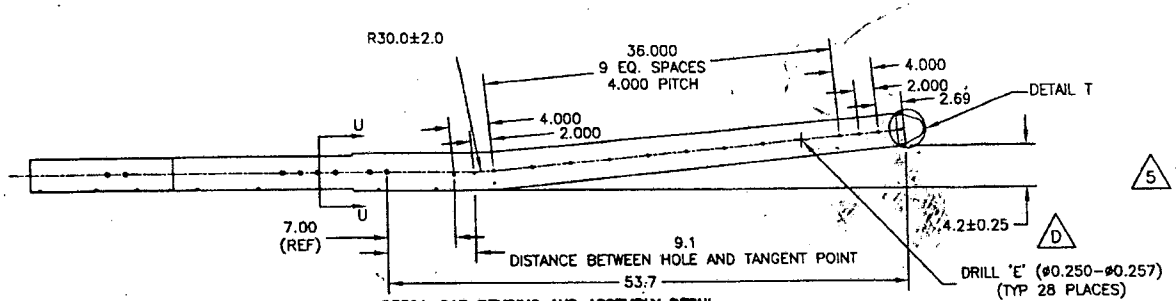
UNDER REVIEW

07.01.15 OK

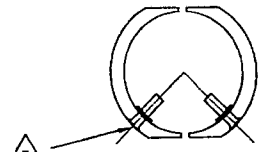
RELEASED

06.05.08

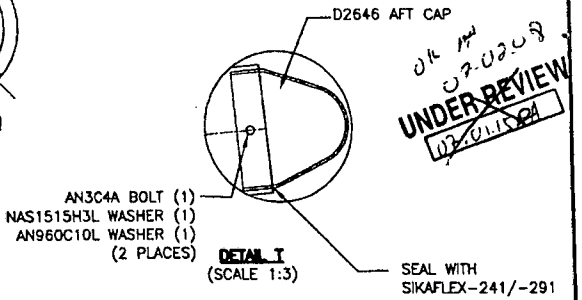
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
PH	PH	
CHECKED	APPROVED	DRAWING NO. D3391 — REV. E
		SHEET 4 OF 5
DATE 06.04.25		TITLE 412 FLOAT SKIDTUBE — SCALE 1:12



D3391-015 BENDING AND ASSEMBLY DETAIL

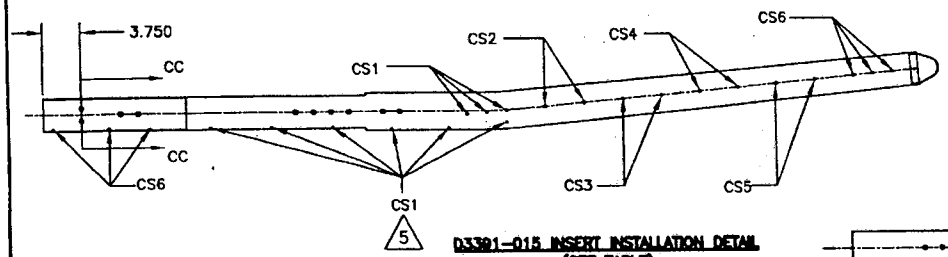


SECTION U–U
(SCALE 1:3)



DETAIL T
(SCALE 1:3)

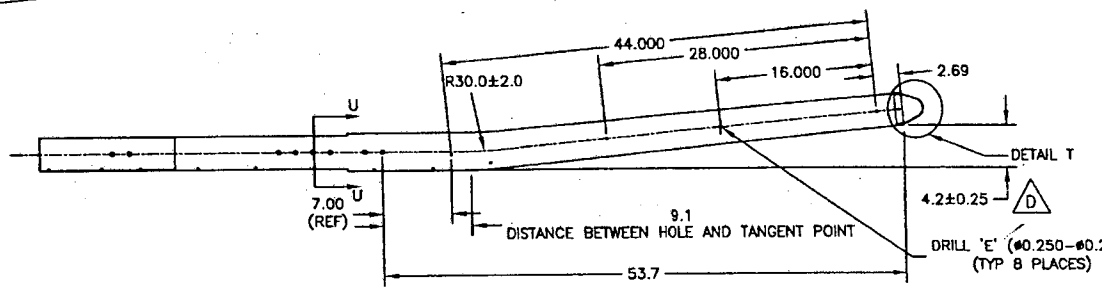
UNDER REVIEW



D3391-015 INSERT INSTALLATION DETAIL
(SEE TABLE)

C'SINK AND INSTALL AESS10KBXXX AND/OR
NAS1330C3KBXXX IN HOLES MARKED CS1–CS6 AS
FOLLOWS

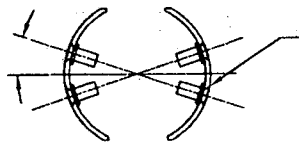
HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	ø0.425	AESS10KB366
CS2	4		ø0.391	AESS10KB366
CS3	4	2	ø0.391	NAS1330C3KB318
CS4	4	2	ø0.391	NAS1330C3KB266
CS5	4		ø0.391	NAS1330C3KB216
CS6	12	8	ø0.391	NAS1330C3KB166



D3391-025 BENDING AND ASSEMBLY DETAIL

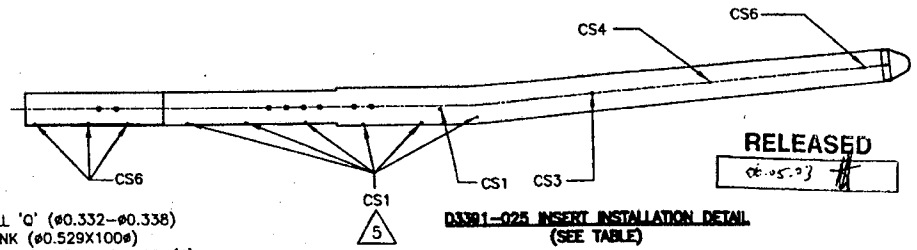
D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB366	INSERT
4	2	NAS1330C3KB318	INSERT
4	2	NAS1330C3KB266	INSERT
4		NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4		NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER



SECTION CC–CC
(SCALE 1:3)

DRILL 'Q' (ø0.332–ø0.338)
C'SINK (ø0.529X100ø)
NAS1330C4KB151 INSERT (1)
(4 PLACES)



D3391-025 INSERT INSTALLATION DETAIL
(SEE TABLE)

RELEASED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
PH	PH		
CHECKED	APPROVED	DRAWING NO.	REV. E
		D3391	SHEET 5 OF 5
DATE		TITLE	SCALE
06.04.25		412 FLOAT SKIDTUBE	1:12

Peter Hum

From: Peter Hum [phum@dartaero.com]
Sent: February 23, 2007 1:51 PM
To: 'Bill Beckett'; 'S Shahbazian'; 'David Shepherd'
Subject: RE: Dart 412 skidtube with Apical Floats

As discussed with Bill, we have decided to allow the release of these skidtubes with the deviation noted below

Peter

From: sjoseph@apicalind.com [mailto:sjoseph@apicalind.com]
Sent: February 23, 2007 1:29 PM
To: phum@dartaero.com
Cc: pbravo@apicalind.com
Subject: RE: Dart 412 skidtube with Apical Floats

Peter

I do not see an issue from a functional standpoint but, I am concerned that customers would object to their decked aft floats not being in alignment with the fwd and mid floats, especially since the aft floats will both lean to one side.

Steve

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Friday, February 23, 2007 9:50 AM
To: Steve Joseph
Subject: FW: Dart 412 skidtube with Apical Floats

Hi Steve,

I originally sent the question below to Pablo. I was wondering if you might be able to help.

Thanks
Peter

From: Peter Hum [mailto:phum@dartaero.com]
Sent: February 23, 2007 10:24 AM
To: Pablo Bravo
Subject: Dart 412 skidtube with Apical Floats

Hi Pablo,

I hope you're enjoying the California winter. We have a decent amount of snow on the ground here.

Please see my attached .pdf drawing. We are trying to send out a Dart 412 float skidtube equipped with the holes for the Apical Tri-bag system (624.8001)

The aft float bag hole provisions are designed in order to have the aft float bag be vertical (i.e. the girt is 90 degress to the horizontal)

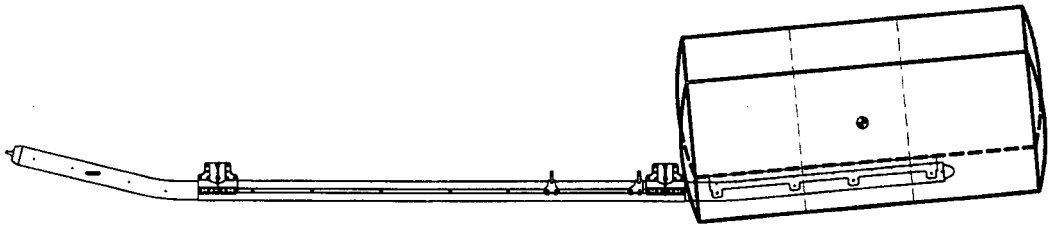
In the manufacturing of the aft portion of the skidtube. The holes for the girt we have made are rotated 6.5 degrees with respect to the vertical, this was a manufacturing error. Therefore, when the bag is installed/or deployed it will be rotated 6.5 degress (inboard or outboard). It will be inboard or outboard depending on which side of the aircraft the skidtube is installed, because the Dart 412 float skids aren't handed.

The forward and mid bags are okay.

Is having the aft float bag rotated by 6.5 degrees inboard or outboard still acceptable for installation on aircraft?

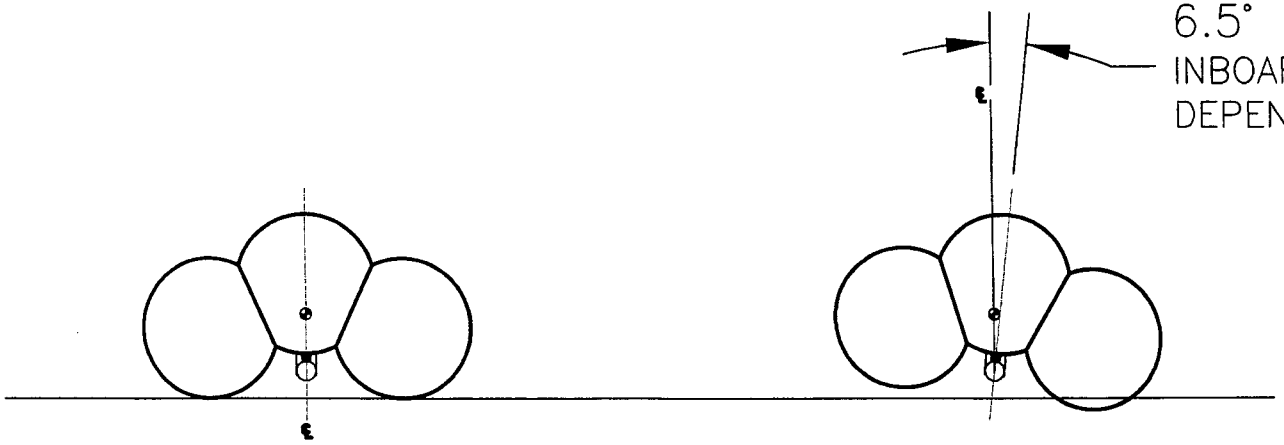
Thanks
Peter

BELL 412 WITH APICAL FLOATS



VIEW A

AFT FLOAT (624.8001)
VOLUME: 67.46 CUBIC FT.



VIEW A